

Work Order ID 55028

January 5, 2010 1:19:51 PM



Page 1

Item ID: D1049

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 05/01/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

RP

Date: 10-1-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D1049

Rev A

100

0.00



SHEAR

Shear

Memo

0.00

Cut Blanks: 2.000" long

mk 10/01/12

20 *✓*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

1-Machine as per folio FA217 & Dwg D1049
2-Deburr

H.A 10/01/12

20 *✓*

HAAS CNC vertical machine #1

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

H.A 10/01/12

20 *✓*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55028

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Process Plan:

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Date:

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

mk 10/01/13

20 0

Quality Control

140

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

M 10-01-13

(x20) 9

Hand Finishing

150

Black Sandtex(Ref:4.3.5.7) per QS1005 4.3

0.00



Powdercoat

Memo

0.00

11109091

=> M 10-01-18

(x20) 0

Powder Coating

START TIME: *2:00pm*
OVEN TEMPERATURE: *320°F*
FINISH TIME: *2:30pm*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 55028

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Accept



Setup Start



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Stop



Item Name: Saddle

Start Date: 05/01/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 15/01/2010 Req Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



BK 10-01-18

20

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location 10

0.00



10-1-18 SL 200

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



10/01/19

QC

Memo

0.00

Quality Control

MF 10-1-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 1:19:56 PM

Page 1

Work Order ID: 55028

Parent Item: D1049

Parent Item Name: Saddle

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X00.25 0		Purchased	No			100	f	12.6400	3.5074			

6061-T6 Bar .750 x .250

.375"

Jan 10.01.12

This Batch Only

M6061T6B0375X00.750

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

12.64

106747

10

107904

1.81

17869

0.83

M 110829

3.5074

ml 10/01/12

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	55028
Description: Saddle		Part Number:	D1049
Inspection Dwg: D1049	Rev: --	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by: <i>H.A</i>	Audited by: <i>smf</i>	Prototype Approval:	N/A
Date: <i>10/01/12</i>	Date: <i>10/01/13</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

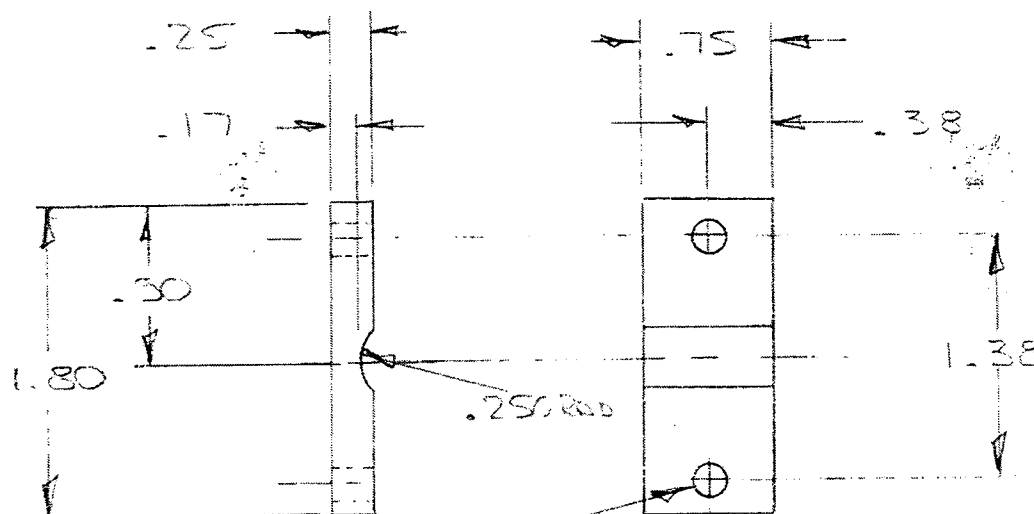
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

RELEASED
9710802 B.



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55028

RL 10-1-05

.203 DIA.
TYP

MATERIAL: SUS 304

FINISH: POWDER COAT



REVISION		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC./VENOR			
DRAWN				BASIC CODE		CONTRACT NO.		DRAWN		DATE		DART		DART AERO ACCESSORIES INC. CANADA			
APPROVED				D=DRIPLE D107=NO OF SHEETS C=COUNTERSINK		LONGEN DASH NO. W=SPOTWELD		DESIGN		1982							
DESCRIPTION OF CHANGE		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .015 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER IN. — 27-2 5. HOLES PER IN. 10007 LIMITS 1. TOLERANCES — .001 .030 2. ANGLES .001 .010 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL SMC CENTRE LINES .005		BASIC CODES 8A-ME2047040 8B-ME2047042		STRESS		FILE		SADDLE		CODE		DNG NO		REV	
		REPORT ALL DISCREPANCIES — DO NOT SCALE.						CLIENT				SCALE		SHT 1 OF 1			

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